

Stop April 6th

Work Order ID 81057

81057

Page 1

March-07-12 2:25:25 PM

Item ID: D4355-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 07/03/2012 Start Qty: 6.00 ~~4.00~~ *6*

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/07 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4355

B

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D4355-1 File

W 12 - 03 - 23 (4)

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB049 and Dwg

FOLIO REV: AA

DWG REV: 3

3-Deburr

PO 12/04/04

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

PO 29

12/04/04

4 0

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

B.A 12/04/04

4 0

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

0.00

Packaging

PP81337

6/24/5 (4)

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/4/10 JF
MF
12-04-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-07-12 2:25:29 PM

Page 1

Work Order ID: 81057

81057

Parent Item: D4355-1

D4355-1

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	573.6043	53	33.47368			
MUHMWB10									**			12 03 23	
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT018

316.48

120035

74.48

120401

242

MAT019

257.1243158

117321

74.6

117738

93.28

117819

83.3

118814

1.5

119145

4.44431579

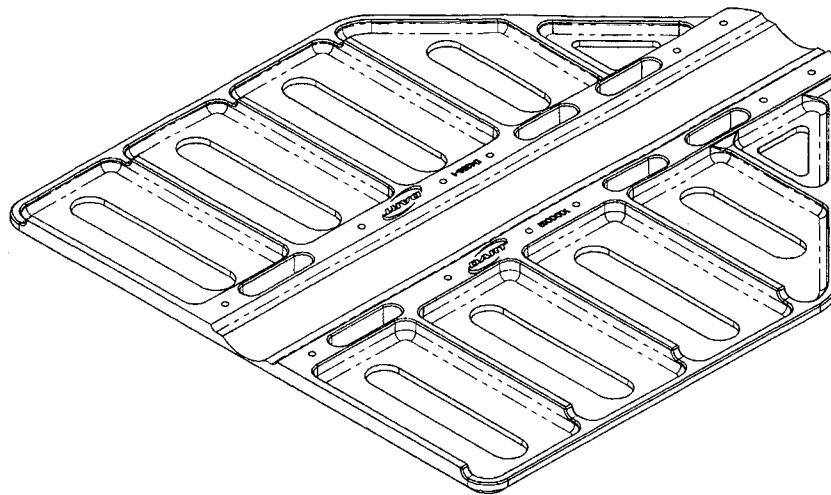
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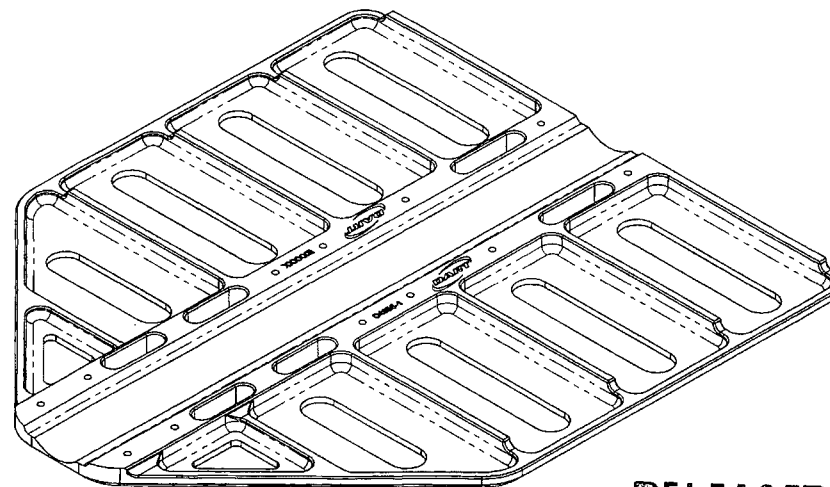
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D4355-1 206L/407 BEARPAW








SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81057 MLJ
12/03/07

RELEASED
2011-05-10

NOTES:

- 1) MATERIAL: UHMW BLACK SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4355-1" AND B/N "BXXXXX"
0.010 - 0.012 DP AS SHOWN
- 7) WEIGHT: 6.88 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP. 

B	SHT 1 WEIGHT CORRECTED WAS 8.41 lbs. SHT 2 RIB DIMS UPDATED. ZN B4 RAD WAS 2.00. SHT 3, SECT. 8-B RIB HEIGHT INCREASED. ALL SHTS DART LOGO UPDATED.		AJS	11.04.26
A	NEW ISSUE		AJS	11.03.21
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D4355	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		206L/407 BEARPAW	NTS	
DATE	11.04.26	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

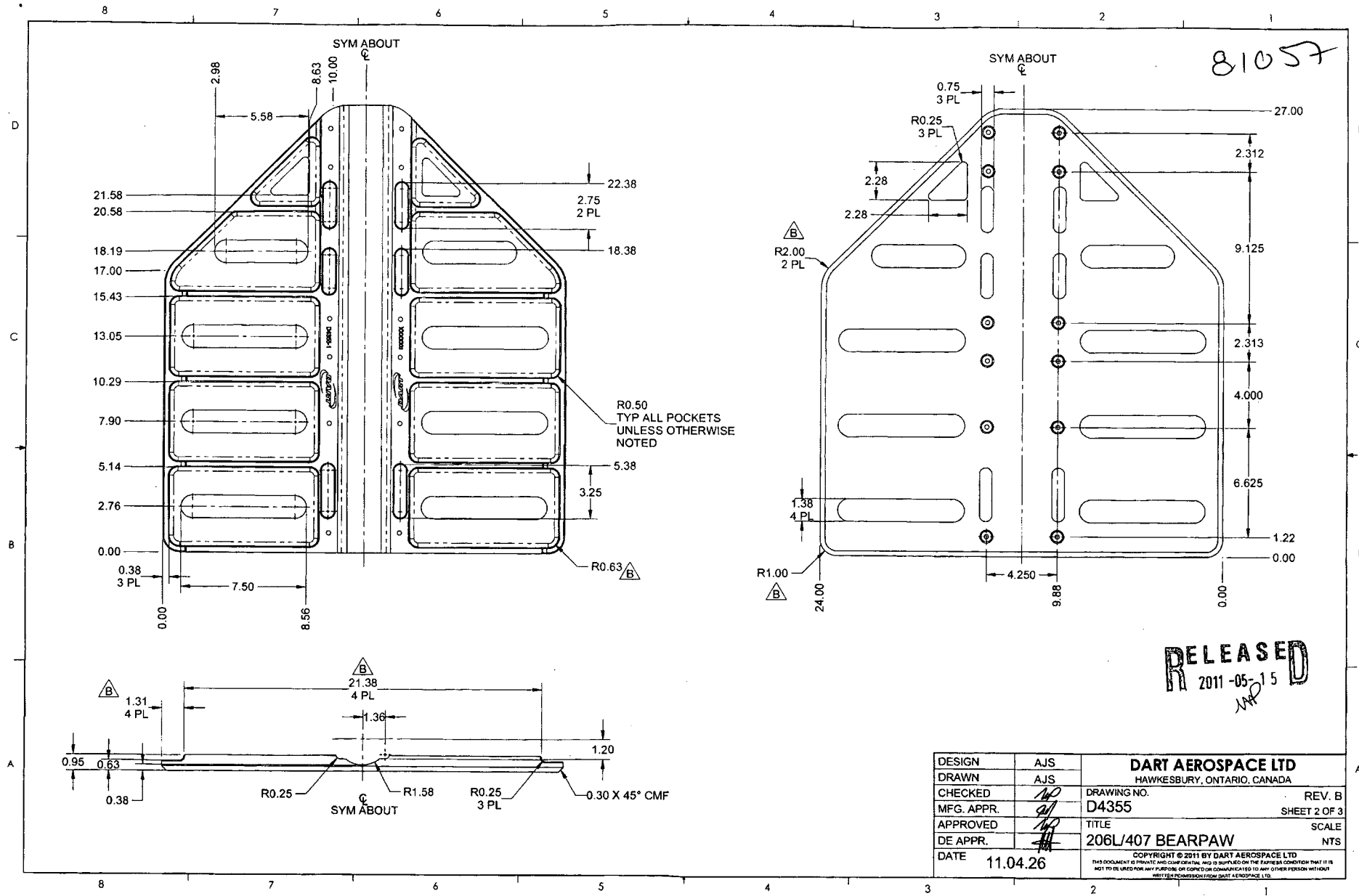
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81057

RELEASED
R 2011-05-15
ND

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ND	DRAWING NO.	REV. B
MFG. APPR.	ND	D4355	SHEET 2 OF 3
APPROVED	ND	TITLE	SCALE
DE APPR.	ND	206L/407 BEARPAW	NTS
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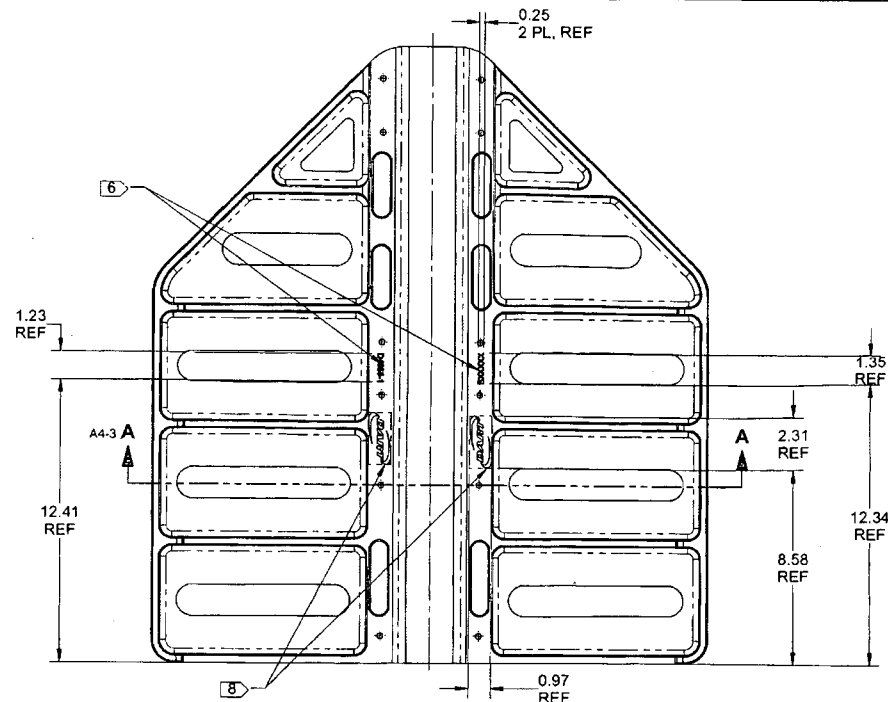
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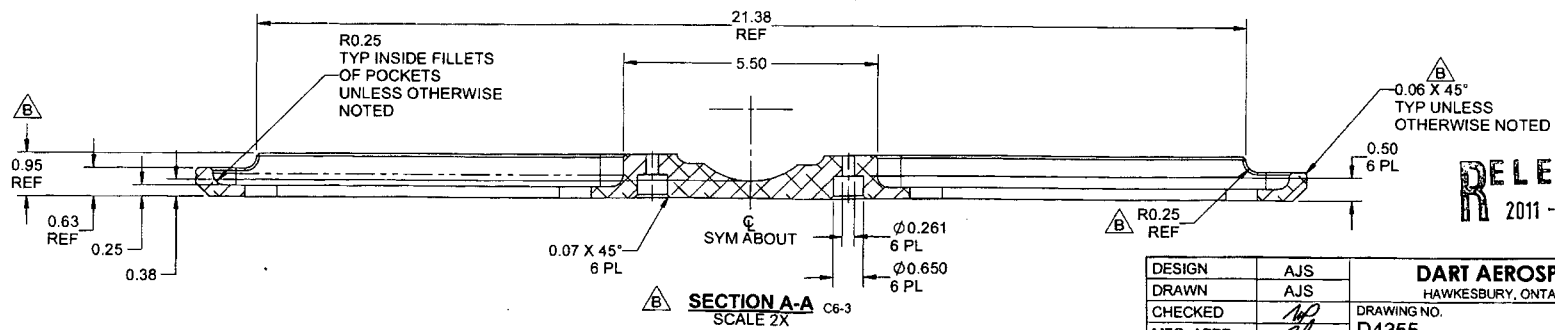
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81057



(SUPPLEMENTAL VIEW)



RELEASED
2011-05-15

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4355	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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DART AEROSPACE LTD		Work Order: 81057
Description: 04355-1		Part Number: 04355-1
Inspection Dwg: 04355-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.00	+/- .030	27.00	✓		PHD-11	TAPE
24.00	± .030	24.00	✓		PHD-11	TAPE
4.250	± .010	4.249	✓		PHD-01	VERN
2.76	± .030	2.763	✓		PHD-01	VERN
1.22	± .030	1.209	✓		PHD-01	VERN
6.625	± .010	6.625	✓		CNC-02	
4.000	± .010	4.000	✓		PHD-01	VERN
0.38	± .030	0.383	✓		"	"
R.25	± .030	0.25	✓		RAD gauge	
0.95	± .030	0.960	✓		PHD-01	VERN
0.63	± .030	0.645	✓		"	"
0.30 x 45°	± .030	0.29 x 45°	✓		"	"
21.38	± .030	21.375	✓		PHD-11	TAPE
1.31	± .030	1.315	✓		PHD-09	
0.75	± .030	0.749	✓		PHD-01	VERN
2.75	± .030	2.742	✓		"	"
0.25	± .030	0.270	✓		"	"
0.38	± .030	0.390	✓		118-126	MIC
Ø 0.261	+ .005 - .001	0.260	✓		PIN gauge	
Ø 0.650	± .010	0.647	✓		PHD-01	VERN
0.50	± .030	0.489	✓		PHD-01	"
0.90 x 45°	± .030	0.075 x 45°	✓		"	"
0.90 x 45°	± .030	0.085 x 45°	✓		"	"

Measured by: PO Rg	Audited by: H.A	Preliminary Approval:
Date: 12/04/04	Date: 12/04/04	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15